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D4610-3

Job Sheet 194000



Part No: D4610-3

Job Qty: 12 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/24/19

Job Tracking No:

Due Date: 5/3/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV B SHEETS 2,3 IPP REV:A NEW ISSUE 12-03-22 JLM VERIFIED BY:EC IPP REV:B 12.04.20 as per dwg rev.B DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Waterjet - Flow - 1	12 pcs		5/3/19	0.00	0.27	Waterjet - Flow			DL 19/05/15
110	QC 2	12 pcs		5/3/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			DL 19/05/15
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			
QC 2 - 66										
QC 2 - 64										
QC 2 - 65										
QC 2 - 5										
QC 2 - 71										
120	QC 8	12 pcs		5/3/19	0.00	0.00	QC 8 - 12			
							QC 8 - 14			
							QC 8 - 17			
							QC 8 - 20			
							QC 8 - 25			
							QC 8 - 3			
							QC 8 - 32			

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				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	MAY 15 2019 40
				QC 8 - 52	9-89
				QC 8 - 23	
140	Small Fab - Brake NC - B4B	12 pcs	5/3/19	0.00 0.50	Small Fab - Brake - 1 - B4B
					Small Fab - Brake - 2 - B4B
					Small Fab - Brake - 3 - B4B
150	QC 5	12 pcs	5/3/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
160	Handfinish - 1-1 Chemical-B4B	12 pcs	5/3/19	0.00 0.50	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
170	QC 7	12 pcs	5/3/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2

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					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
180	Packaging 3-1 - Stock - B4B	12 pcs	5/3/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC ST 104
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	12 pcs	5/3/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	
Part Op 100 - 1-Cut as per Dwg D4610 Dwg Rev: <u>B</u> Prog Rev: <u>B</u> 2-Debur as required Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 140 - Bend as per dwg 150 - QC5- Inspect part completeness to step on W/O 160 - Chemical Conversion Coat per QSI005 4.1 170 - QC7-Inspect Chemical Conversion Coat 180 - Identify as per dwg & Stock Location: 190 - QC21- Final Inspection - Work Order Release						DAS 21 9-89 MAY 29 2019
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M2024T3S.040	2024-T3 .040 Sheet	2.4000 sf (.2 ea)	100-Waterjet - Flow - 1			

Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M2024T3S.040	2	164	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.129Inches + 0.006 - 0.001	0.135 0.128	Diameter	0.1285
2	Doubler	3.650Inches ± 0.030	3.680 3.620		3.651
3	Doubler	4.390Inches ± 0.030	4.420 4.360		4.40
4	Doubler	0.909Inches ± 0.010	0.919 0.899		0.917
5	Doubler	0.740Inches ± 0.030	0.770 0.710		0.740
6	Doubler	1.285Inches ± 0.010	1.295 1.275	Diameter	1.285
7	Doubler	1.500Inches ± 0.010	1.510 1.490	Diameter	1.500
8	Doubler	1.960Inches ± 0.030	1.990 1.930		1.960
9	Doubler	1.061Inches ± 0.010	1.071 1.051		1.066
10	Doubler	2.160Inches ± 0.030	2.190 2.130		2.161
11	Doubler	5.920Inches ± 0.030	5.950 5.890		5.93
12	Doubler	1.640Inches ± 0.030	1.670 1.610		1.642
13	Doubler	0.040Inches ± 0.010	0.050 0.030		0.042

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Container No: S181411



Part: D4610-3

Job No: 194000

Serial No/Batch: S181411

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 05/15/19